



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-C-03

Job Sheet 189347



Part No: RBE350A94-3700-C-03

Job Qty: 40 pcs

Part Name: Bolt



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/23/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 18.01.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Conventional Lathe - 1 SL-154	10 pcs		2/8/19	0.50	2.50	Conventional Lathe - 1 Conventional Lathe - 2	SL-154	JB 19-04-12
130	QC 2	10 pcs		2/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		JB 19-04-12
							QC 2 - 63		

<

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Tel: (613) 632-5200
Email: sales@dartaero.com
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Container No: S172246

Part: RBE350A94 - 3700 - C - 03

Job No: 189347

Serial No/Batch: S172246

Revision: 6

Inspector:

Exp Date:

Indication:

1/23/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 2 - 8	
140	Conventional Mill - 1 - B4B	10 pcs	2/8/19	0.00 2.00	Conventional Mill - 1 - B4B
					Conventional Mill - 2 - B4B
150	QC 2	10 pcs	2/8/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 38
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 54
					QC 2 - 56
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
160	QC 8	10 pcs	2/8/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 38
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
170	Outsource - 12 - Black Oxide	10 pcs	2/8/19		GRO002-VC 10
180	Packaging 2-1 - Receive - B4B	10 pcs	2/8/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B

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				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	bp APR 22 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 6	10 pcs	2/8/19	0.00 0.00	QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	DAS APR 22 2019 68
				QC 6 - 61	9-89
200 Packaging 3-1 - Stock - B4B	10 pcs	2/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS 28 9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	

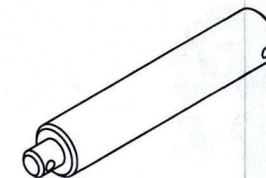
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	10 pcs	2/8/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	9-20 APR 23 2019
Part Op 120 - (Manufacture as per dwg), 1-Machine as per DWG 2-Deburr Descriptions: 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - 1-Machine as per DWG 2-Deburr 150 - (QC2- Inspect parts off machine FAI/FAIB) 160 - (QC8- Inspect parts - second check) 170 - -Issue P/O; PO <u>047199</u> -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required 180 - (Receive & Inspect for Damage & Mat'l Certs) 190 - (QC6- All purchased or subcontracted products) 200 - (Identify as per dwg & Stock Location:_____) 210 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
92580A112	Threaded Rod 5/8-18	3 ft (.3 ea)	120-Conventional Lathe - 1	5092519	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
120-Conventional Lathe - 1	92580A112	3	33	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	15-0213	-03 CH'D HOLE WAS Ø3.1 mm IS Ø.129 - .125, CH'D DIM WAS Ø.315 S.F. -.07 IS Ø.3159 - .3150.	8/14/2015	RJC	JAG
6	16-0286	-03 CH'D DIM WAS Ø.3159/.3150 IS Ø.3159/.3155 (S.F. -.07), WAS .217 IS .217 +.005/.000, WAS 2X Ø.129/.125 THRU IS 2X Ø.129/.125 THRU ALL (P.F. -11), ADDED FINISH SPEC QMSI-6.2.2, B.O. REV'D.	2/28/2017	RJC	SM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189347405
19-01-23



5/8-18 UNF -2A

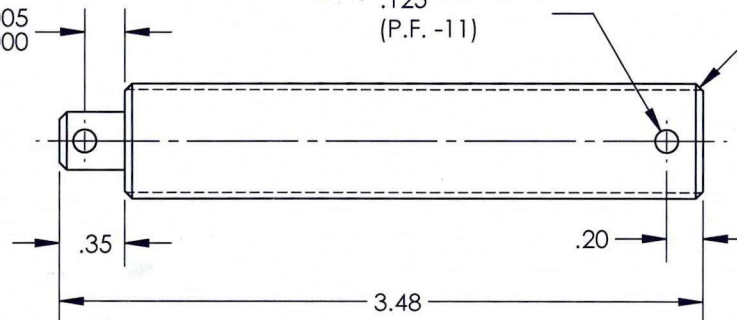
Ø.3159
Ø.3155
(S.F. -.07)



.217^{+.005}
-.000

2X Ø.129
THRU ALL
(P.F. -11)

3X .04 X 45°



(-03)

ALL THREAD

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE	
DWG NO. RBE350A94-3700-C-03	REV 6
MAT'L B7 STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 1:1	DATE 8/21/2012 SHEET 4 OF 7



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043199



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043199

PO Date: 4/15/19

Due Date: 4/22/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189347	RBE350A94- 3700-C-03	Bolt -Issue P/O; PO -Black oxide finish, MIL-C- 13924C Class 1 -Certificate of Conformity is required	Firmed - <i>XB4</i>		4/22/19 APR 22 2019	34 pcs	0 pcs <i>DP</i>	34 pcs	\$3.529/pcs	\$119.99

Grand Total: \$119.99

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/16/19 9:13 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018514-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

018514- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
18-Apr-2019		SPARTAKOS BOUNTOURIS		PO043199					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBE350A94-3700-C-03 Rev.	RBE350A94-3700-C-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	34	34	0	0	0	

Notes Additionnelles / Additional Notes

1 box

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.